

Date: Monday, 12/01/2009 2:37:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE ASSEMBLY
 Job Number : 44664
 Estimate Number : 12709
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 40532
 Part Number : D3572041
 Drawing Number : D3572 REV.C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 10/02/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : 1209.01.13
 Comment : Est Rev:A New Issue 07-02-07 JLM
 est rev B revB dwg EC
 Est Rev:C Removed D3572-7 Cap 07-06-11 JLM
 Est Rev:D 08-05-27 Review process of Est. DD verified
 by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D35723 Guide



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)
 GUIDE
 Batch: 10x40562 10x44818 ~~10x44818~~ EL 9-2-17 (20)

3.0 D35725 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 BRACKET
 Batch: B32415 EL 9-2-17 (5)

4.0 M6061T6T1000W188 6061T6 RD TUBE 1.00 X .188W



✓ Comment: Qty.: 2.3405 f(s)/Unit Total : 14.0427 f(s)
 6061-T6 Round Tube 1.00"x 0.188 wall
 Batch: M104779 X134.5" M109041 x 53.5" - 26.5" = EL 9-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:10 PM
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Drawing Name: GUIDE ASSEMBLY

Job Number: 44664

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut Tube D3572-1 as per Dwg D3572

2-deburr both ends

EL 9-2-17 x6

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-17 (6)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572

A/R AL ROD

Batch: M110130

EL 9-2-18 x5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-18

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

8.0



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush at the end of tube only

EL 9-2-18 x5

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-19 (5)

12.0

HAND FINISHING1


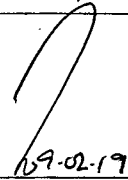
HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-02-18 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-02-19	8.0	QC 5 not necessary. Move 10.0 to 8.0; have the QC 9, then QC 5 after work is completed.	dy	09/02/20		 09-02-19	 09-02-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: GUIDE ASSEMBLY

Job Number: 44664

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



11109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:00am

HL

09-02-19

(X5)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-02-19

15.0

PACKAGING 1

PACKAGING RESOURCE #1



(SV)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 247

9/2/19

SP

16.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/2019

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

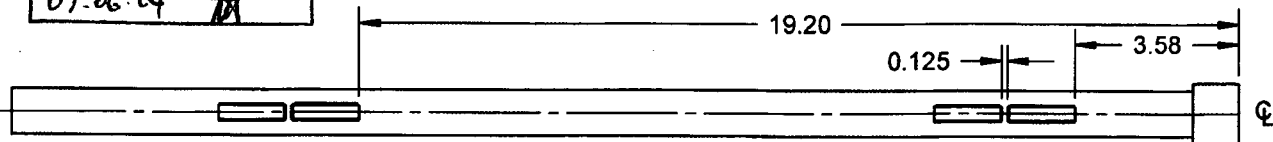
NOTE: Date & initial all entries



DESIGN <i>LG</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED

07-06-01 *H*



D3572-3 GUIDE
(4 PLACES)

3/16

4X

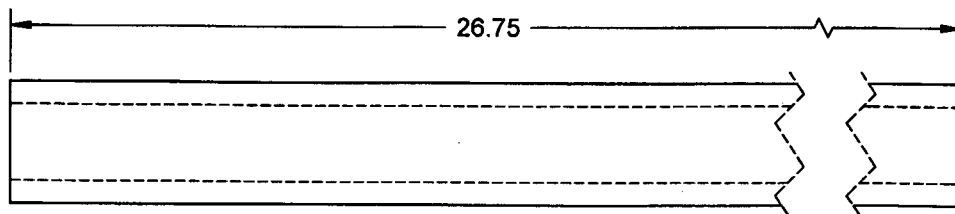
D3572-1 TUBE

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

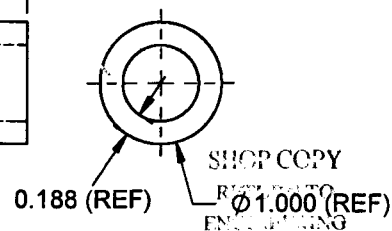
- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004



D3572-1 TUBE

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER VVV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



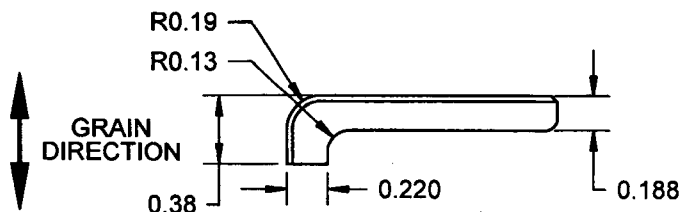
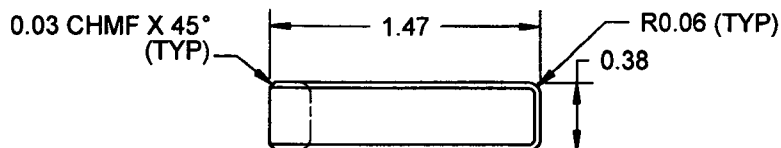
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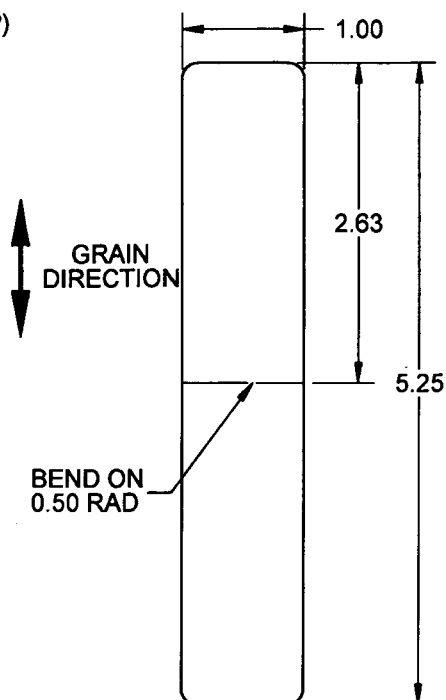
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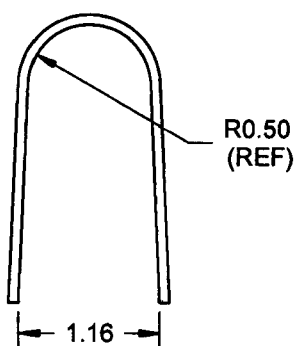
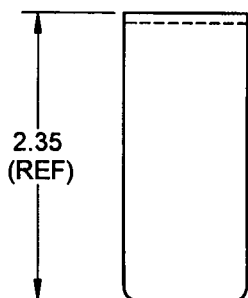
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)

RELEASED
07.06.01 *H*

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/110 (OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080))
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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